

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022431**Date Inspected:** 05-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhou Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 2G position for OBG Cross beam CB17, welding of UT repair weld No. CB3001A-017-014. The Welder is identified as 066459. ZPMC Quality Control is identified as Mr. Li Yang. The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR-1. The repair report is identified as CWR2892 R0. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for OBG segment 13AW, welding of UT repair weld No. SEG3013AD-067. The Welder is identified as 067572. ZPMC Quality Control is identified as Mr. Shen Jian Bao. The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as WR20573. The In-process SMAW appears to be progressing in compliance with approved contract documents.

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SMAW in the 4G position for OBG segment 13AE, welding of UT repair weld No. SEG3007AD-026. The Welder is identified as 037743. ZPMC Quality Control is identified as Mr. Li Hua Jie. The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as WR20494. The In-process SMAW appears to be progressing in compliance with approved contract documents.

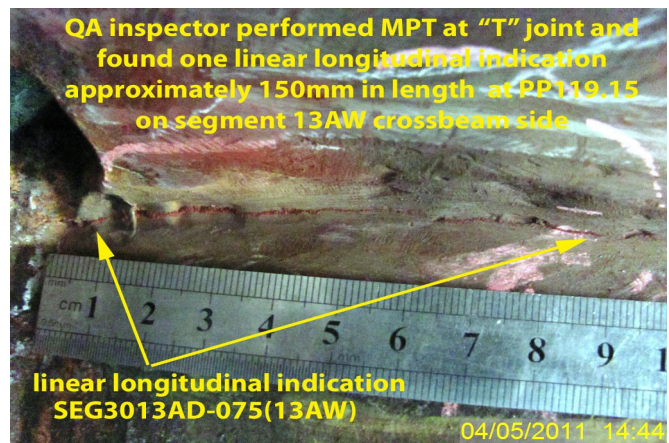
SMAW in the 4G position for OBG segment 13AE, welding of UT repair weld No. SEG3007AD-045. The Welder is identified as 067183. ZPMC Quality Control is identified as Mr. Li Hua Jie. The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as WR20494. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 3G position for OBG segment 13AE, welding of UT repair weld No. SEG3007Q-002. The Welder is identified as 066422. ZPMC Quality Control is identified as Mr. Li Hua Jie. The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1. The repair report is identified as WR20507. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 2G position for OBG segment 13AW, welding of weld No. SEG3013-001. The Welder is identified as 066443. ZPMC Quality Control is identified as Mr. Shen Jian Bao. The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1. The In-process SMAW appears to be progressing in compliance with approved contract documents.

During visual inspection at Panel Point PP119.15 at crossbeam side of segment 13AW this QA inspector observed one linear longitudinal indication approximately 150mm in length. The weld joint is identified as SEG3013AD-075. After that this QA confirmed with magnetic particle testing. Then the QA inspector informed to ABF QA Mr. Wen Jian Bo and ZPMC QC Mr. Shen Jian Bao to make weld repair report and repair that mention weld joint. For more information please see the attached photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer
